

Split

Work Order ID 96191-2

January-24-13 7:59:05 AM

96191

2360

D2360

B96101

B96101

Page 1

Item ID: D2360

B96101

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Litter Tie Down Assembly

Stop *NS2*

Start Date: 1/21/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/06/13

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 13-01-25

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2341

Rev F

D2360

Rev D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 12.65" Long

PD 13/02/15

10 0

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio D2341 and Dwg D2341
2-Debur

F.K. 13/02/22
JFC/ba 2013-02-23

10 0

000001

03 00

0001

0000

Work Order ID 96191

January-24-13 7:59:05 AM

96191

Page 2

Item ID: D2360 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Litter Tie Down Assembly
 Start Date: 1/21/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/06/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						10	0		
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130						10	1		
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						10			
HandFinish	Memo	0.00							
Hand Finishing									

PK 13/02/22
JFC 10 2013-02-23

24 3-2-25

10 7613226

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Page 3

Item ID: D2360

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Tie Down Assembly

Start Date: 1/21/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/06/13

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME: 3:15

OVEN TEMPERATURE: 320°

FINISH TIME: 3:45

0.00

10 φ 13-2-27

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

10x

13/04/04

170

Small Fab

0.00

170

Small Fab

Small Fab

Memo

Assemble as per dwg D2360

0.00

13.04.22

Open hole at .250

Work Order ID 96191

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96191

Page 4

Item ID: D2360 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Litter Tie Down Assembly
 Start Date: 1/21/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 2/06/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							(4) 13-08-01 PD
Quality Control									
190	Identify as per dwg & Stock Location: <u>ST 221</u>	0.00							
190									
Packaging	Memo	0.00							13/1/21 (4)
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							MLC 13-08-09
Quality Control									MF

13-8-01

Picklist Print

January-24-13 7:59:03 AM

Page 1

Work Order ID: 96191
Parent Item: D2360
Parent Item Name: Litter Tie Down Assembly

Start Date: 1/21/13
Start Qty: 4.00

Required Date: 2/06/13
Required Qty: 4.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R18 Screw		Purchased	No			170	Each	593.0000	1	4		FF 13-07-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		93							
				4523		93							
				ST346		500							
				108079		400							
				110099		100							
AN960JD10 Washer	NAS1149D0363J	Purchased	No	124392		170	Each	0.0000	2	8		FF 13-07-30	
AN960JD10L Washer	NAS1149D0332J	Purchased	No	125807		170	Each	0.0000	8	32		FF 13-07-30	
D2002-015 Knob		Manufactured	No	98 241		170	Each	0.0000	2	8		FF 13-07-30	
D2345 Lock Channel		Manufactured	No			170	Each	21.0000	1	4		FF 13-07-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA 99626		21							
				86349		21							
D2366 Lock Handle		Manufactured	No			170	Each	22.0000	2	8		FF 13-07-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009 98330		22							
				86351		3							
				89161		19							

Picklist Print

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Page 2

Work Order ID: 96191

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 1/21/13

Required Date: 2/06/13

Start Qty: 4.00

Required Qty: 4.00

D2367	Manufactured	No	170	Each	13.0000	1	4	PP 13-07-30
Handle Knob								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST009 95711	13			4	
			83541	1				
			89083	12				
D2372	Manufactured	No	170	Each	15.0000	2	8	FF 13-07-30
Quick Release								
			<u>Location</u> 99010	<u>Loc Qty</u>	<u>Loc Code</u>			
			GA 97848	15			3	
			86001	2				
			92199	13				
D2373	Manufactured	No	170	Each	19.0000	1	4	FF 13-07-30
Spring								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST009 98341	19			1	
			86352	19			3	
D2444	Manufactured	No	170	Each	3.0000	1	4	FF 13-07-30
Pip Pin Assembly								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			GA 90455	3			4	
			88498	3				
D6201	Manufactured	No	100	f	46.4586	1.054	4.4378948	
"T" Extrusion								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			MAT028	46.45863153				PD 13/02/15
			81421	13.1586315				
			83987A	20				
			89645	13.3				
			121613 = 83987				3.2	end of Batch
			124572 = 96508				7.5	MTL NOT Potted

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 96191

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 1/21/13

Required Date: 2/06/13

Start Qty: 4.00

Required Qty: 4.00

MS20470AD3-4
Rivet, Universal Head

Purchased

No

170

Each

8,602.0000

1

4

FF 13-07-30

Location

Loc Qty

Loc Code

GA

270

15541

270

4

ST319

8332

111477

8332

MS21042L3
Nut

Purchased

No

170

Each

7,678.0000

3

12

FF 13-07-30

Location

Loc Qty

Loc Code

FP001

3

122141

3

12

GA

434

122452

434

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

6973

123900

2973

124291

4000

MS27039-1-13
Screw

Purchased

No

170

Each

568.0000

1

4

FF 13-07-30

Location

Loc Qty

Loc Code

GA

16

119736

16

4

ST304

52

119736

52

10

ST506

500

124326

500

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Shop Packet Print

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Picklist Print

January-24-13 7:59:04 AM

Page 4

Work Order ID: 96191

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 1/21/13

Required Date: 2/06/13

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-15

Purchased

No

170

Each

1,078.0000

2

8

FF 13-07-30

Screw

Location

Loc Qty

Loc Code

ST305

78

123352

78

ST506

1000

124326

1000

20 8 FF

NAS679A3W

Purchased

No

170

Each

184.0000

1

4

FF 13-07-30

Nut

Location

Loc Qty

Loc Code

GA

5

1463

5

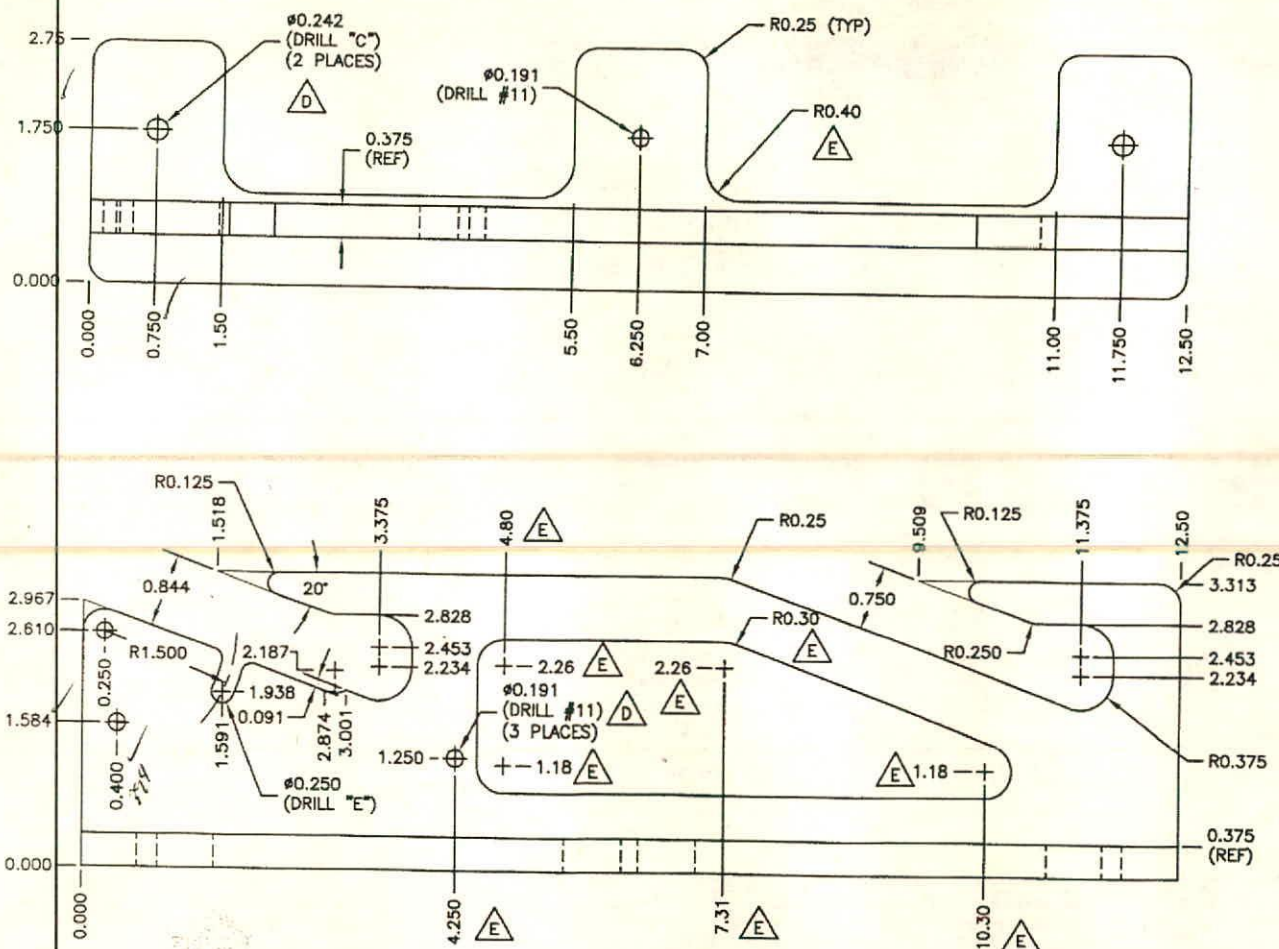
2409

179

4

DART

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION
(6061-T6/T651 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT
PERMANENT INK MARKER

RELEASED

07-06-22

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16196

DART**RELEASED**

97 06 07

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

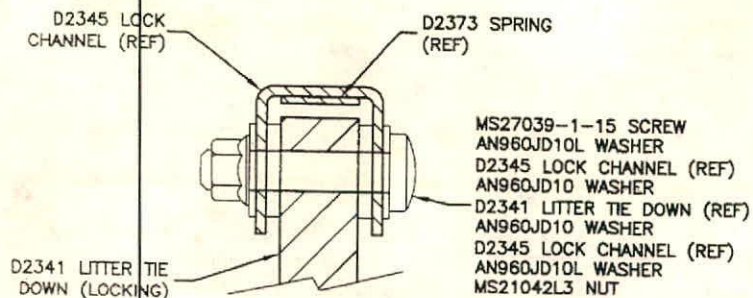
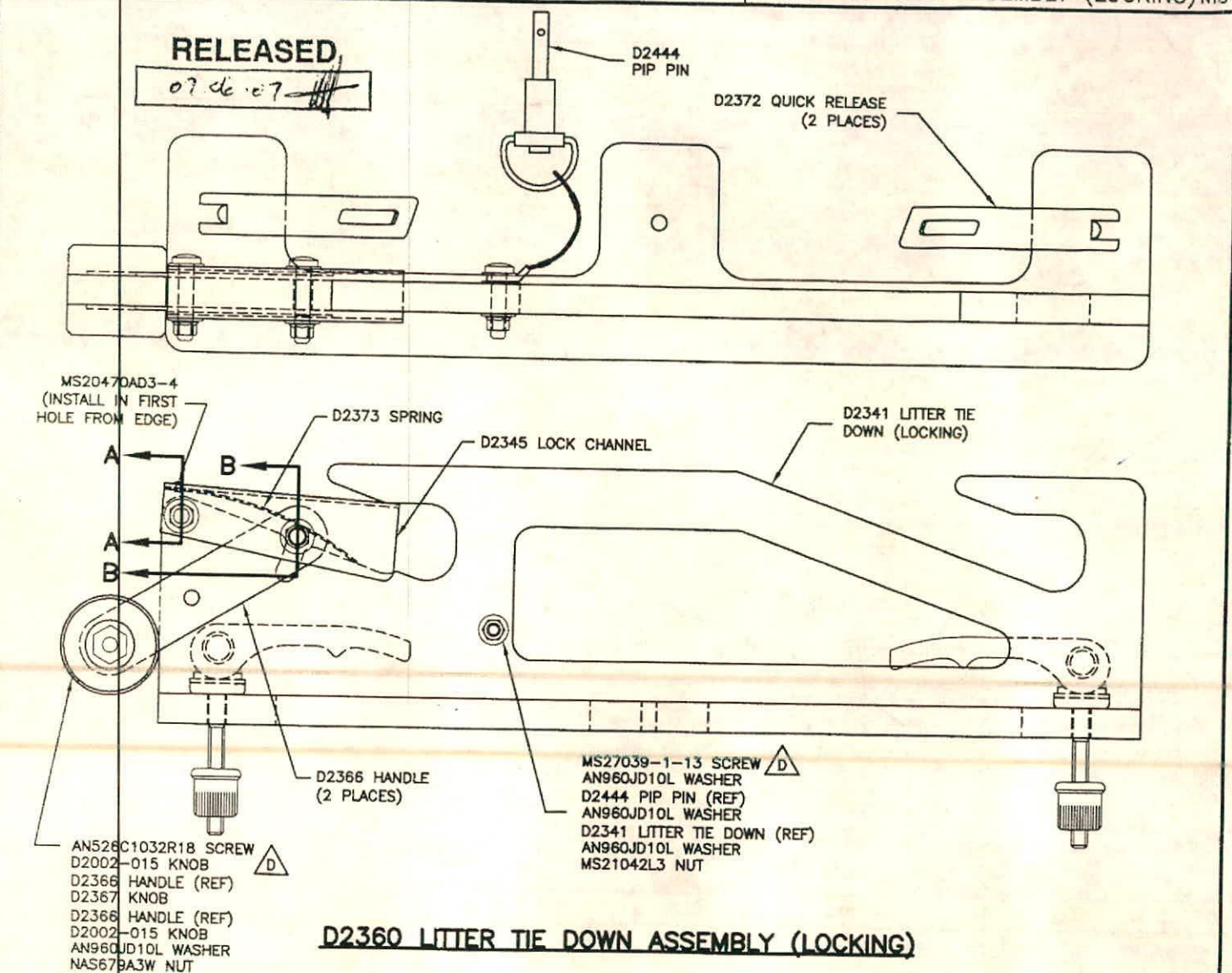
96191 M-5
13-01-25

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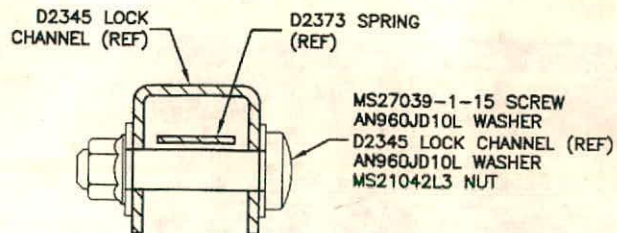
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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06	TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS		SCALE



SECTION A-A
(SCALE 1:1)



SECTION B-B
(SCALE 1:1)

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96191

DART AEROSPACE LTD		Work Order:	96191
Description: Litter Tie Down Bracket (Locking)		Part Number:	D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.742	✓		FK-01	Vern
2.75	+/-0.030	2.752	✓		"	"
Ø0.242	+0.005/-0.001	.242	✓		"	"
Ø0.191	+0.005/-0.001	.191	✓		"	"
R0.25	+/-0.030	.25	✓		"	"
R0.40	+/-0.030	.40	✓		"	"
12.50	+/-0.030	12.750	✓		FK-05	Tape
11.750	+/-0.010	11.750	✓		CNC-02	Vern
11.00	+/-0.030	11.00	✓		FK-05	Tape
7.00	+/-0.030	7.00	✓		CNC-02	Vern
6.250	+/-0.010	6.25	✓		"	"
5.50	+/-0.030	5.50	✓		"	"
1.50	+/-0.030	1.50	✓		FK-01	Vern
0.750	+/-0.010	.752	✓		"	"
0.400	+/-0.010	.399	✓		"	"
1.584	+/-0.010	1.584	✓		"	"
2.610	+/-0.010	2.610	✓		"	"
0.250	+/-0.010	.249	✓		"	"
0.844	+/-0.010	.842	✓		"	"
Ø0.250	+/-0.010	.249	✓		"	"
0.750	+/-0.010	.750	✓		"	"
3.313	+/-0.010	3.312	✓		"	"
4.250	+/-0.010	4.250	✓		"	"
1.250	+/-0.010	1.247	✓		"	"

Measured by: FK	Audited by: [Signature]	Prototype Approval:	N/A
Date: 13/02/22	Date: 13.2.25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	

